

Work Order ID 66678

Wednesday, February 23, 2011 3:26:59 PM

Page 1

Item ID: D3201-1

Accept

Revision ID:

Item Name: Doubler

Start Date: 3/2/2011 Start Qty: 12.00

Required Date: 3/4/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-02-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3201

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3201 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

2024.340

B11-2-28

(15)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-2-28

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sub 2/25

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66678

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Item ID: D3201-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 3/2/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr Stack								
140 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							
150 QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00							

Handwritten: n/a

Handwritten: 12x

Handwritten: 12. PR 11-2-28.

W/O:		WORK ORDER CHANGES					
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Item ID: D3201-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 3/2/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: *Cy*

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/3/01 10**11/03/01**CL 11/03/01*

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NOTE: Date & initial all entries

Picklist Print

Wednesday, February 23, 2011 3:27:06 PM

Page 1

Work Order ID: 66678

Parent Item: D3201-1

Parent Item Name: Doubler



Start Date: 3/2/2011

Required Date: 3/4/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-25 JLM
IPP Rev:B Now on Waterjet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

192.2595

0.276

3.486316

4.2



B11-2-29

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT

11.8

114415

11.8

MAT22

180.4595

110305

21.93

111786

7.66

112291

22.45

112331

52

113162

76.4195

112291

(15)

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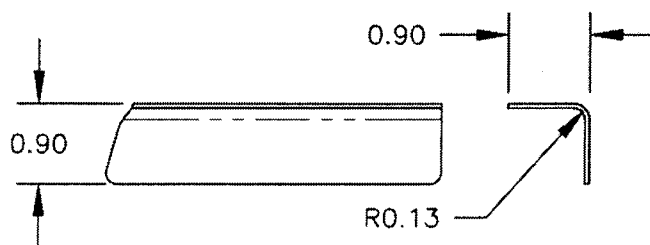
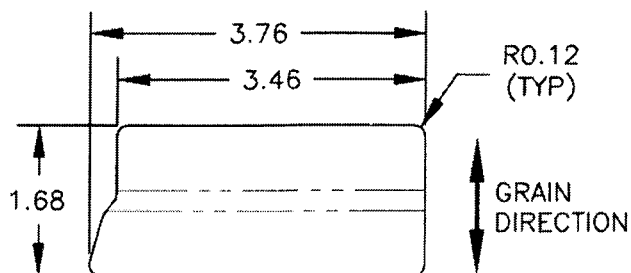
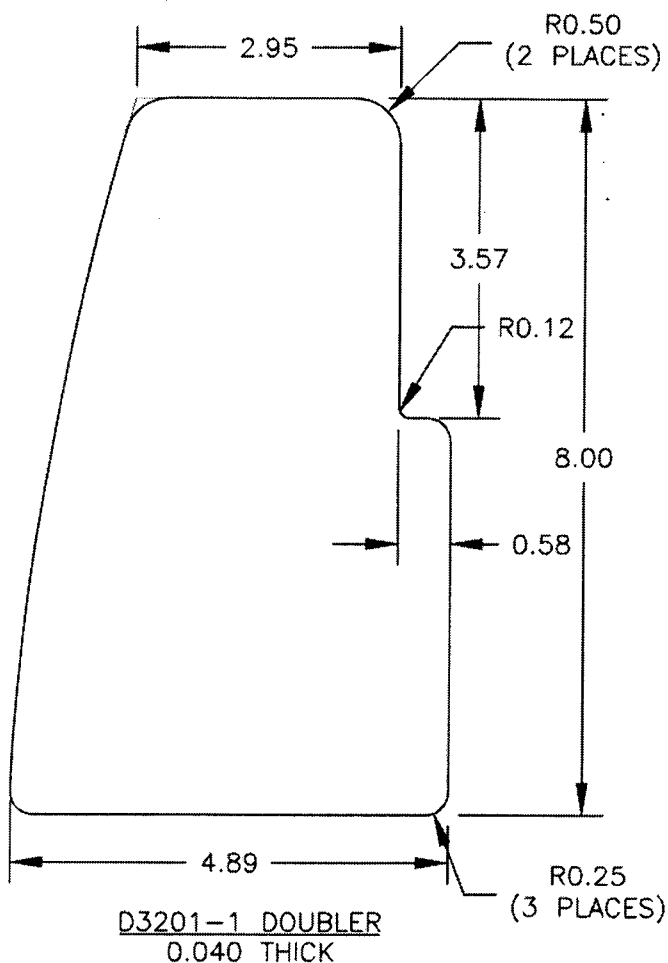
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE 03.11.03		TITLE DOUBLER	SCALE 1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

RELEASED
03.11.14 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *66678* *01/11-02-23*



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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